

# LORD® 506 Acrylic Adhesive

## with LORD Accelerator 4, 17 or 19

### Description

LORD® 506 acrylic adhesive when mixed with LORD Accelerator 4, 17 or 19 creates a semi-flexible adhesive system that will quickly bond a wide variety of thermoplastics and thermoset plastics.

LORD 506 acrylic adhesive can be mixed with either LORD Accelerator 4, LORD Accelerator 17 or LORD Accelerator 19. LORD Accelerator 4 is a no-mix accelerator applied to the substrate before the acrylic adhesive. LORD Accelerators 17 and 19 must be mixed into the acrylic adhesive prior to application. LORD Accelerator 19 is available in off-white or black. For further detailed information on LORD Accelerator 4, LORD Accelerator 17 and LORD Accelerator 19, refer to the applicable data sheet.

### Features and Benefits

**Versatile** – bonds a wide variety of substrates including ABS, acrylic, polycarbonate, FRP, prepared metals, urethane, phenolic, polysulfone, and vinyl; can be used with both Mix-In and No-Mix accelerators.

**Convenient** – cures very quickly at room temperature.

**Durable** – accommodates shock and sudden stress loading.

**Temperature Resistant** – performs at temperatures from -40 to +300°F (-40 to +149°C).

**Environmentally Resistant** – resists dilute acids, alkalis, solvents, greases, oils and moisture; provides excellent resistance to UV exposure and weathering.

**Non-Sag** – remains in position when applied on vertical or overhead surfaces, allowing for greater process flexibility.

### Application

**Surface Preparation** – Remove grease, loose contamination or poorly adhering oxides from metal surfaces. Normal amounts of mill oils and drawing compounds usually do not present a problem in adhesion. Most plastics require a simple cleaning before bonding. Some may require abrading for optimum performance.

### Typical Properties\*

Appearance	Off-white Paste
Viscosity, cP @ 77°F (25°C) Brookfield HBF Spindle 3, 5 rpm	20,000-70,000
Density	
lb/gal	8.25-8.65
(kg/m <sup>3</sup> )	(989-1036)
Flash Point (Closed Cup), °F (°C)	53 (12)

\*Data is typical and not to be used for specification purposes.

# LORD TECHNICAL DATA

## Mixing

- No-Mix Accelerator  
LORD 506 acrylic adhesive and LORD Accelerator 4 are not mixed prior to application.
- Mix-In Accelerator  
Mix LORD 506 acrylic adhesive with the proper amount of LORD Accelerator 17 or 19. Handheld cartridges will automatically dispense the correct volumetric ratio of each component. Even color distribution visually indicates a thorough mix. Once mixed, the adhesive cures rapidly.

## Applying

- No-Mix Accelerator  
Apply LORD Accelerator 4 to one or both substrate surfaces. Allow accelerator to dry. For further details on the use of LORD Accelerator 4, refer to the LORD Accelerator 4 data sheet.  
  
Once accelerator is dry, apply adhesive to the other substrate surface using a handheld cartridge or automatic dispense equipment. Mate the two surfaces and slide into correct position within the working time of the adhesive.
- Mix-In Accelerator  
Apply mixed adhesive using handheld cartridges or automatic meter/mix/dispense equipment.  
*Handheld Cartridges*
  1. Load the cartridge into the applicator gun and remove the end caps.
  2. Level the plungers by expelling a small amount of adhesive to ensure both sides are level.
  3. Attach mixing tip and expel a mixer's length of adhesive.
  4. Apply adhesive to substrate and mate the parts within the working time of the adhesive. Clamp in position until adhesive reaches handling strength.

## Meter/Mix/Dispense Equipment

Contact your LORD representative if assistance is needed using this equipment. When using such equipment, all wetted parts must be made of stainless steel and all hoses should be steel braided Teflon®.

**Curing** – Cure begins immediately once adhesive and accelerator come in contact. Handling strength is achieved within 8-12 minutes. Complete cure will take 24 hours at room temperature. Mating surfaces should be fixtured as soon as possible (within 4-6 minutes) after adhesive application.

## Shelf Life/Storage

Shelf life is six months when stored at temperatures under 80°F (27°C) in original, unopened container. For maximum shelf life, storage temperatures of 40-50°F (4-10°C) are recommended. If stored at these cooler temperatures, allow product to return to room temperature before using.

## Cautionary Information

Before using this or any LORD product, refer to the Material Safety Data Sheet (MSDS) and label for safe use and handling instructions.

*For industrial/commercial use only.* Must be applied by trained personnel only. Not to be used in household applications. Not for consumer use.

*Teflon is a registered trademark of E.I. duPont de Nemours and Company.*

# LORD TECHNICAL DATA

## Typical Properties\* of Adhesive Mixed with Recommended Accelerator

Mix Ratio by Volume, Adhesive to Accelerator

A4	No-Mix
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A17	10:1
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A19 or A19 Black	10:5
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Solids Content, %	—
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Working Time, min @ 75°F (24°C)	4-6
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Time to Handling Strength**, min @ 75°F (24°C)	8-12
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Mixed Appearance

A4	—
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A17	Tan Paste
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A19	Tan Paste
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A19 Black	Gray Paste
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Cured Appearance

A4	—
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A17	Tan to Green
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A19	Tan to Green
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A19 Black	Black
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\*Data is typical and not to be used for specification purposes.

\*\*Dependent on ambient air temperature and mass; established when adhesive reaches 100 psi.

# LORD TECHNICAL DATA

Values stated in this technical data sheet represent typical values as not all tests are run on each lot of material produced. For formalized product specifications for specific product end uses, contact the Customer Support Center.

Information provided herein is based upon tests believed to be reliable. In as much as LORD Corporation has no control over the manner in which others may use this information, it does not guarantee the results to be obtained. In addition, LORD Corporation does not guarantee the performance of the product or the results obtained from the use of the product or this information where the product has been repackaged by any third party, including but not limited to any product end-user. Nor does the company make any express or implied warranty of merchantability or fitness for a particular purpose concerning the effects or results of such use.

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**LORD Corporation**  
**World Headquarters**

111 Lord Drive  
Cary, NC 27511-7923  
USA

**Customer Support Center** (in United States & Canada)

+1 877 ASK LORD (275 5673)

[www.lord.com](http://www.lord.com)

For a listing of our worldwide locations, visit [LORD.com/locations](http://LORD.com/locations).